



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5033-1
Job Sheet 167125



Part No: D5033-1

Job Qty: 320 ea

Part Name: Rigid Polyurethane Foam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/25/17

Job Tracking No:

Due Date: 11/15/17

Created By: Chantal Lavoie

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
100	Purchasing	320 pcs		11/15/17	0.00	0.00	Purchasing	SP-124
110	Packaging	320 pcs		11/15/17	0.00	0.00	Packaging2	SP-124
120	QC	320 pcs		11/15/17	0.00	0.00	QC6	38
130	Packaging	320 pcs		11/15/17	0.00	0.00	Packaging3	9-89
140	QC21-SA	320 Ea		11/15/17	0.00	0.00	QC21	11-1820

Part Op 100 - Issue P/O: _____ Vendor: ACP COMPOSITES Vendor Part#: LP-06D 1/8"
Descriptions: 110 - Ensure material release note is attached
130 - LOCATION: MAT020

DEC 05 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Purchasing	LP-FC125-FG1-9	320	0	0	0

Part Specifications

Specifications could not be found.

Plex 10/25/17 7:26 AM dart.lavoie.chantal

DART
AEROSPACE
S017019



Rigid Polyurethane Foam

PART NO: D5033 – 1

Revision:

Operation:

Change No:

Purchasing – SF

Mfg Date: 12/04/17

Job No: 167125

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K64 1K7

CANADA

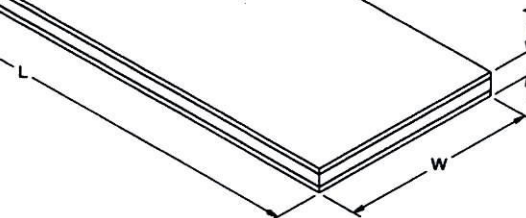
TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

SPECIFICATION CONTROL DRAWING

AX-3110 FIBERGLASS 1 PLY LAYER
FR3706 POLYURETHANE FOAM
AX-3110 FIBERGLASS 1 PLY LAYER



D5033-X



DART PART NUMBER	DESCRIPTION	POSSIBLE VENDOR	VENDOR PART NUMBER	MATERIAL	W	L	T	WEIGHT (lbs)
D5033-1	RIGID POLYURETHANE FOAM	ACP COMPOSITES	LP-FC125-FG1-9	PER FIGURE	48	96	0.125	1.97

**DAS
13
9-89**

OCT 25 2017

W/O: 167125

NOTES:

- 1) MATERIAL: PER FIGURE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5033-X" & DART B/N PER DART QSI 044 6.1
- 7) WEIGHT: SEE TABLE

RELEASED

2015 JAN 28

ECN 14-634

APPROVED

B	LP-FC125-FG1-9 WAS LP-08D 1/8" (ZN B5-1)	RF	14.11.28
A	NEW ISSUE	RF	13.12.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5033	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	FOAM CORE	NTS
DATE	14.11.28	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038142

Supplier: ACP001-VU
ACP Composites
78 Lindbergh Ave,
Livermore, CA 94551 USA
Phone: 925-443-5900
Fax: 925-443-5900

PO No: PO038142

PO Date: 10/25/17

Due Date: 11/20/17

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

E-MAILED
10/25/17

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: COD

Freight Terms:

Special Comments:

Items													
Line Item	Part	Rev	Supplier Part No	Item No	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	LP-FC125-FG1-9	-	✓		Fiberglass 1 Ply/Foam Panel 125"x48"x96" As per Dwg D5033 Rev. B		Firmed	11/13/17	320 sf	0 sf	320 sf	\$14.1172/sf	\$4,517.50
Line Item Note Job # 167125													
2	LP-FC125-FG1-9	-	✓		Fiberglass 1 Ply/Foam Panel 125"x48"x96" As Per Dwg D5033 Rev. B		Firmed	11/20/17	384 sf	0 sf	384 sf	\$14.1172/sf	\$5,421.00
Line Item Note job# 167126													
												Grand Total: \$9,938.51	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

[Signature]
J.B.

Plex 10/25/17 9:00 AM dart.baker.diane



ACP Composites, Inc
78 Lindbergh Ave.
Livermore CA 94551
United States
(925) 443-5900
www.acpsales.com

Packing Slip # 12095

Order #
Order Date

88584
10/25/2017

PO #
Ship Date
Ship Via
Tracking #

PO038142
11/17/2017
Freight Economy
ForwardAir60638457

Ship To

Chantal Lavoie
Dart Aerospace Ltd.
1270 Aberdeen
Hawkesbury ON K6A 1K7
Canada

Line	Item	Description	Units	Ordered	Shipped	Inventory Detail
1	LP-FC125-FG1-9 ✓	.125" x 48" x 96" 6PCF Foam Core, 1 Ply Fiberglass Panel .141" +/- 15% Thickness Tolerance +/- .250" L/W Tolerance Freight Shipping Required	Ea	10	10 ✓	Ware-R9(10) <i>SPR-12-4</i>
2	LP-FC125-FG1-9 ✓	.125" x 48" x 96" 6PCF Foam Core, 1 Ply Fiberglass Panel .141" +/- 15% Thickness Tolerance +/- .250" L/W Tolerance Freight Shipping Required	Ea	12	12	Ware-R9(12)
	*ADDHAN-C	Additional Handling Required	Ea	1	1	
	*CERT-STANDARD	Standard Certificate of Conformance Required This is for both Lines # 1 and 2		2	2	



88584

Commercial Invoice

Shipper/Exporter

ACP COMPOSITES
78 LINDBERGH AVENUE
LIVERMORE, CA 94551 USA
(925)443-5900

Consignee

Chantal Lavoie
Dart Aerospace Ltd.
1270 Aberdeen
Hawkesbury ON K6A 1K7
Canada
(613) 632-5200

Intermediate Consignee**Date**

20-November-2017

Invoice No.

88584/12095

Customer PO No.

PO038142

Currency Used

USD

Country of Origin

USA

B/L / AWB No.

Forward Air 60638457

Final Destination

Canada

Export Route / Carrier

Terms of Sale

FOB

Terms of Payment

Net30

Terms of Freight

No. of Packages

1

Notes**Item & Description****HS No.****Unit Value****Quantity****Weight: Lbs.****Value**

Fiberglass / Foam Panels, .125" x 48" x 96" 7019190000 \$451.75 22 200 \$9938.50

Sub Totals

22

200.00

\$9938.50

Freight

\$0

Insurance

\$0

Total Value

\$9938.50

I hereby certify this commercial invoice to be true and correct.

Shipper

Title

Date



Certificate of Conformance

QP-22-03F

Revision: B

Date: August 18, 2015.

RETAIL CERTIFICATE OF CONFORMANCE - STANDARD

Customer: Dart Aerospace Ltd.

Part #: LP-FC125-FG1-9

Description: .125" x 48" x 96" 6PCF Foam Core, 1 Ply Fiberglass Panel

Quantity Shipped: 12 (Second Shipment)

Order #: PO038142 / SO 88584

It is hereby certified that the materials detailed above conform to the current ACP or manufacturer's datasheet or specifications, PO requirements (if applicable) and are in conformance with ACP Composites' quality standards.

If you have any questions, please contact us at (925) 443-5900.

Jessica Sparr
Vice President
jrsparr@acpsales.com

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D 503 (6 PCF Foam Core)

PO / BATCH NO.: 38142 / 5088584
5017019

DATE: 17-12-04

MATERIAL CERT REC'D: Yes
QUANTITY RECEIVED: 10 X 4 X 8
QUANTITY INSPECTED: 10 X 4 X 8
QUANTITY REJECTED: 0

THICKNESS ORDERED: .125
THICKNESS RECEIVED: .125
SHEET SIZE ORDERED: 4 X 8
SHEET SIZE RECEIVED: 4 X 8

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	☒ N	
CORRECT FINISH	☒ Y	N	
CORROSION	Y	☒ N	
CORRECT GRAIN DIRECTION	☒ Y	N	
CORRECT MATERIAL PER M-DRAWING	☒ Y	N	<u>LP-FC125-FG1-9</u>
CORRECT THICKNESS	☒ Y	N	
PHOTO REQUIRED	Y	☒ N	
CORRECT REF # TO LINK CERT	☒ Y	N	
CORRECT MATERIAL IDENTIFICATION	☒ Y	N	<u>HT: PO 38142</u>
CORRECT M# ON THE MATERIAL	☒ Y	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>38</u> <u>9-89</u>	SIGNED OFF BY: _____
DATE: <u>NOV 04</u>	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER REQUIREMENTS
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART RELEASED M-DRAWING
- 6- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING & RECORD
note Aluminum material only

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN **20pcs** FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER